

Work Order ID 112377

January-30-14 2:33:53 PM

112377

Page 1

Item ID: D4918-047

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 1/30/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-01-31

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject , Insp.
Number Stamp

Draw Nbr

Revision Nbr

D4918

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER FILE D4918-7

PROG REV: D4918

DWG REV: A

DEBURR

4 mm/2 14/03/21

105

QC2- Inspect parts off machine FAI/FAIB

0.00

105

QC

Memo

0.00

Quality Control

4 mm/2 14/03/21

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Page 2

Item ID: D4918-047

Accept

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Setup Start

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Stop

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Item Name: Wearplate Assembly

Start Date: 1/30/14

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Required Date: 1/30/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

107

QC8- Inspect parts - second check

0.00

27

9-89

107

0.00

14/3/24

4

QC

Memo

Quality Control

108

Form as per dwg

0.00

DAS
30
9-89

108

0.00

4

Brake NC

Memo

Brake NC

14/03/24

109

QC5- Inspect part completeness to step on W/O

0.00

30

14/3/24

109

0.00

4

QC

Memo

Quality Control

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Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

4

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

120

Large Fab

Memo

0.00

Large Fab

1- Weld hardcoat on as per dwg
A/R 2059b hardcoat Batch#: m127456

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 112377

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112377

Page 4

Item ID: D4918-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 1/30/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Small Fab	Memo	0.00				4			14-03-25 CR
Small Fab	Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: <u>128 296</u>	0.00							
160 *160* QC	QC5- Inspect part completeness to step on W/O	0.00				4			
Quality Control	Memo	0.00							
170 *170* Packaging	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00				x4	1	11	14/03/26
Packaging	Memo	0.00							

Work Order ID 112377

January-30-14 2:33:53 PM

112377

Page 5

Item ID: D4918-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 1/30/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14-03-31

Picklist Print

January-30-14 11:38:10 AM

Page 1

Work Order ID: 112377
 Parent Item: D4918-047
 Parent Item Name: Wearplate Assembly

Start Date: 1/30/14 Required Date: 1/30/14
 Start Qty: 4.00 Required Qty: 4.00

Comments: IPP REV:A 13.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	369.0170	0.412	1.7347368		mm 14/07/21	

Location

Loc Qty

Loc Code

MAT020

369.017

M126915

2.487

M127821

166.53

M128054

200

2.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

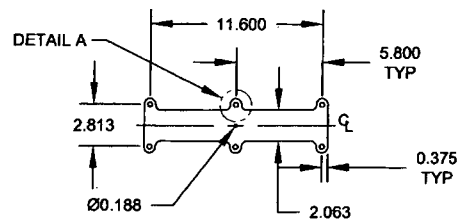
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

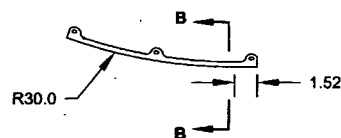
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

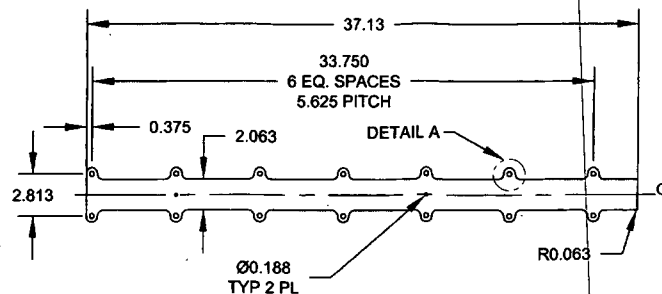
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



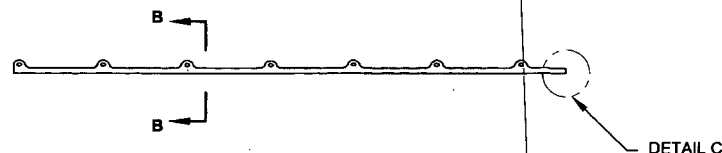
D4918-1F FLAT PATTERN



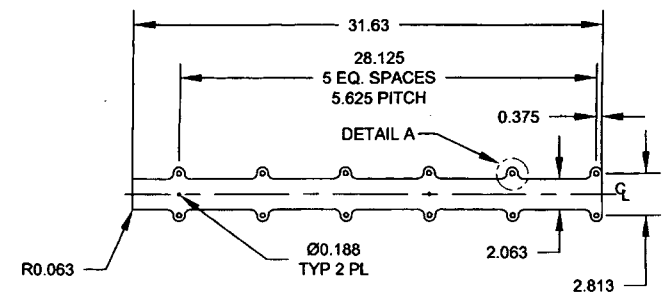
D4918-1 BENDING DETAIL
(MAKE FROM D4918-1F)



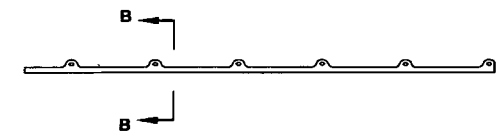
D4918-3F FLAT PATTERN



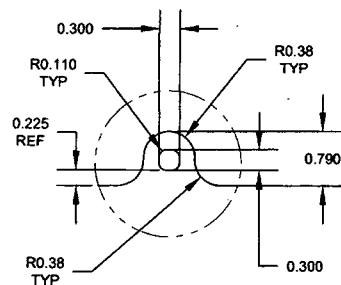
D4918-3 BENDING DETAIL
(MAKE FROM D4918-3F)



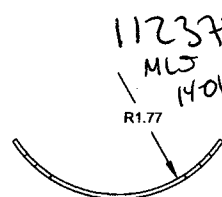
D4918-5F FLAT PATTERN



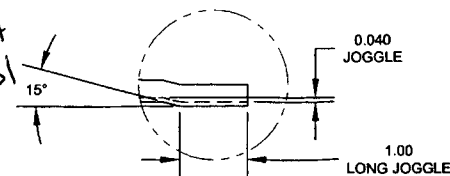
D4918-5 BENDING DETAIL
(MAKE FROM D4918-5F)



DETAIL A
(SCALE 4X)



SECTION B-B
(SCALE 4X)



DETAIL C
(SCALE 4X)

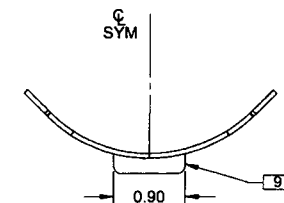
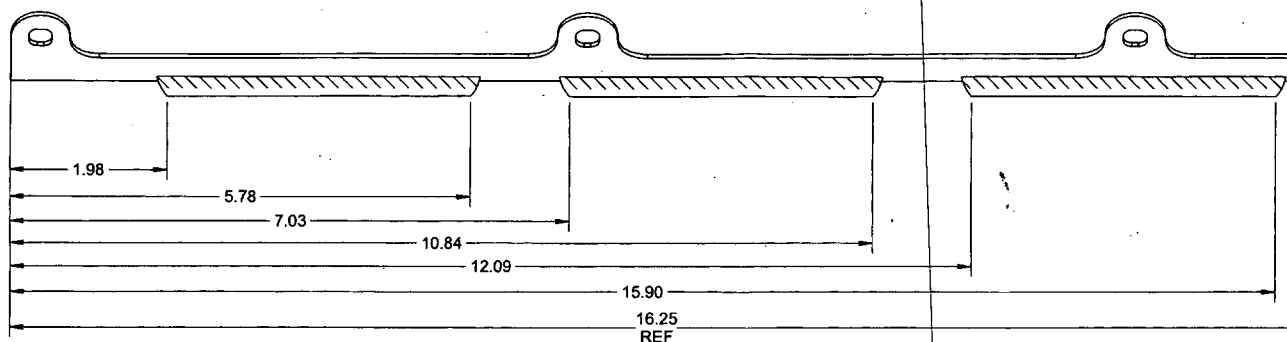
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4918-1 - 0.47 lbs, D4918-3 - 0.95 lbs, D4918-5 - 0.77 lbs,
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

RELEASED
2013-12-10

A		NEW ISSUE		DW	13.08.30
REV.	DESCRIPTION			BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC			
DRAWN	DW				KENT, WA
CHECKED	CP	DRAWING NO.	REV. A		
MFG. APPR.		D4918	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		WEARPLATE	NTS		
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC			
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ITEM	QTY	P/N	DESCRIPTION
1	X	D4918-047	WEARPLATE
2	1	D4918-7	WEARPLATE
3	A/R	2059B	HARDCOAT



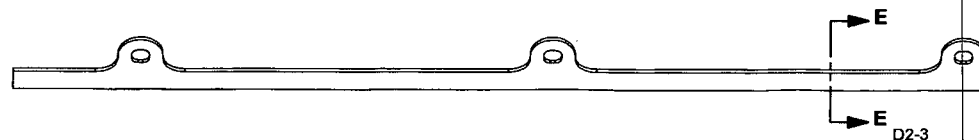
D4918-047 WEARPLATE

NOTES:

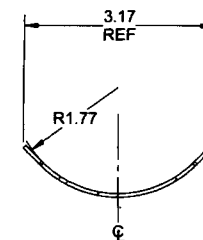
- 1) MATERIAL: PER PARTS LIST
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4918-047" PER QSI 044 6.1
- 7) WEIGHT: 2.18 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

RELEASED
2013-12-10

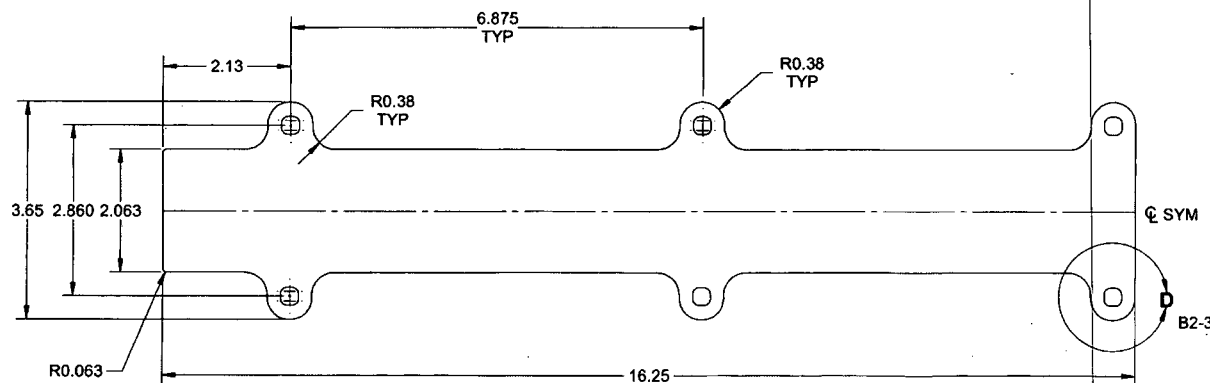
DESIGN	DW	DART AEROSPACE LTD KENT, WA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4918	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE WEARPLATE	SCALE NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	13.08.30		



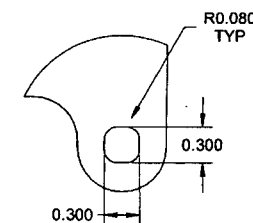
D4918-7 WEARPLATE
(MAKE FROM D4918-7F)



SECTION E-E
SCALE 2X D4-3



D4918-7F WEARPLATE
FLAT PATTERN



DETAIL D
SCALE 2X B4-3

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.66 lbs

RELEASE
2013-12-13

DESIGN	DW	DART AEROSPACE LTD KENT, WA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4918	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	13.08.30	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	